

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027199**Date Inspected:** 30-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai**CWI Name:** Wai Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Bay Number 1

This inspector did not observe any welding or contract work in this bay today.

Bay Number 2

FCAW welding of complete joint penetration and partial penetration weld joint(s) located on lift 14 OBG anchorage plate assembly identified as SA3032-001 weld number(s) 866 & 867. Welder is identified as welder no. 069712. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-13-P-2333-TC-P4-F and WPS-B-T-2233-TC-U4b-F.

FCAW welding of complete joint penetration and partial penetration weld joint(s) located on lift 14 OBG anchorage plate assembly identified as SA3032-001 weld number(s) 581 & 582. Welder is identified as welder no. 067877. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-13-P-2333-TC-P4-F and WPS-B-T-2233-TC-U4b-F.

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FCAW welding of complete joint penetration and partial penetration weld joint(s) located on lift 14 OBG anchorage plate assembly identified as SA3032-001 weld number(s) 491 & 492. Welder is identified as welder no. 066673. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-13-P-2333-TC-P4-F and WPS-B-T-2233-TC-U4b-F.

FCAW welding of complete joint penetration and partial penetration weld joint(s) located on lift 14 OBG anchorage plate assembly identified as SA3032-001 weld number(s) 332 & 333. Welder is identified as welder no. 045143. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-13-P-2333-TC-P4-F and WPS-B-T-2233-TC-U4b-F.

FCAW welding of complete joint penetration and partial penetration weld joint(s) located on lift 14 OBG anchorage plate assembly identified as SA3032-001 weld number(s) 520 & 521. Welder is identified as welder no. 201583. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-13-P-2333-TC-P4-F and WPS-B-T-2233-TC-U4b-F.

FCAW welding of complete joint penetration and partial penetration weld joint(s) located on lift 14 OBG anchorage plate assembly identified as SA3032-001 weld number(s) 618 & 619. Welder is identified as welder no. 068852. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-13-P-2333-TC-P4-F and WPS-B-T-2233-TC-U4b-F.

FCAW welding of complete joint penetration and partial penetration weld joint(s) located on lift 14 OBG anchorage plate assembly identified as SA3032-001 weld number(s) 528 & 529. Welder is identified as welder no. 048696. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-13-P-2333-TC-P4-F and WPS-B-T-2233-TC-U4b-F.

FCAW welding of complete joint penetration and partial penetration weld joint(s) located on lift 14 OBG anchorage plate assembly identified as SA3032-001 weld number(s) 295 & 296. Welder is identified as welder no. 066236. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-13-P-2333-TC-P4-F and WPS-B-T-2233-TC-U4b-F.

Bay Number 3

Performed verification VT for the component(s) and corresponding welds for component on OBG Floor Beam component listed as FB3263-001 for the following designated weld number(s): 001~022, 025, 028, 033, & 042~069. This QA inspector signed green tag #15206.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG Longitudinal Diaphragm component identified as LD3040-001 weld number(s) 081, 085, 097, & 101. Welder is identified as welder no. 206623. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2232-TC-U4b-F.

FCAW welding of fillet weld joint(s) located on lift 14 OBG sub assembly identified as SA3338-001 weld number(s) 051~058 & 061~062. Welder is identified as welder no. 208035. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2132-3.

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FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG Floor Beam component identified as FB3273-001 weld number(s) 051 & 052. Welder is identified as welder no. 050242. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2232-TC-U4b-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG Floor Beam component identified as FB3273-001 weld number(s) 042, 045, & 046. Welder is identified as welder no. 044830. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2232-TC-U4b-F & WPS-B-T-2233-TC-U4b-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG Floor Beam component identified as FB3272-001 weld number(s) 002, 019, 029, & 042. Welder is identified as welder no. 052696. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U4b-F.

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) longitudinal diaphragm component identified as LD3042-001. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Chen Xi was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSR1-9735.

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) longitudinal diaphragm component identified as LD3041-001. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Chen Xi was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSR1-9734.

Bay Number 4

FCAW welding of fillet weld joint(s) located on lift 14 OBG sub assembly identified as SA3361-001 weld number(s) 016, 017, 022, & 023. Welder is identified as welder no. 217805. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2132-3.

FCAW welding of fillet weld joint(s) located on lift 14 OBG sub assembly identified as SA3364-001 weld number(s) 009, 010, 012, 013, 018, & 019. Welder is identified as welder no. 217805. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2132-3.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents

Summary of Conversations:

Pertinent conversations are included in the body of the report.

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Rene	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
